Split

Work Order ID 112028 -(

112028

Tuesday, January 28, 2014 1:41:01 PM

Item ID: D4808-041 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Rod End Bearing Assembly

Start Date: 1/28/2014 **Start Qty:** ~~6.00~~ 4 *6*

Required Date: 2/14/2014 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** mf **Date:** 14-1-28 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Draw Nbr	Revision Nbr	DAS
D4808	A	27 9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00							
100	DOOSAN LATHE					mjh 14/1/30			
Outsource5	**Memo**	0.00							
Outsource process - Machining	ISSUE P.0: 22838 POSSIBLE SUPLIER:ATG C OF C IS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	**Memo**	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
140						6			
QC	**Memo**	0.00							
Quality Control	100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT								

WA DAS 27 9-89

DAS 27 9-89 14/3/12

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 112028

112028

Tuesday, January 28, 2014 1:41:01 PM

Item ID: D4808-041 **Accept** *N900040100*

Revision ID:

Item Name: Rod End Bearing Assembly

Start Date: 1/28/2014 **Start Qty:** 6.00 *6*

Required Date: 2/14/2014 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	PURCHASING	0.00 DAS 27 9-89							
150									
Outsource2	**Memo**	0.00							
Outsource process - NDT	Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required								
160	Receive & Inspect for Damage & Mat'l Certs	0.00				lex	SP 14-3-12.		
160									
Packaging	**Memo**	0.00							
Packaging	Ensure certificate of conformity is attached								
161		0.00				4	FF	14-03-18	
161									
Small Fab	**Memo**	0.00							
Small Fab	SWAGE AS PER DWG								

QC 5 → 14/3/18 DAS 27 9-89

4

→ ST 123

4X 14-3-18 DAS 26 9-89

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Date: _____ Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D4808-041 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Rod End Bearing Assembly
Start Date: 1/28/2014 **Start Qty:** 6.00 *6* **Cust Item ID:**
Required Date: 2/14/2014 **Req'd Qty:** 6.00 *6* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	**Memo**	0.00				_____	_____	previous page	
Quality Control									
180	Identify as per dwg & Stock Location:_____	0.00							
180									
Packaging	**Memo**	0.00				_____	_____	previous page	
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00				MLJ	14-03-19		
Quality Control									

BJ 14-03-19

Picklist Print

Tuesday, January 28, 2014 1:41:01 PM

Work Order ID: 112028

Parent Item: D4808-041

Parent Item Name: Rod End Bearing Assembly

Start Date: 1/28/2014 **Required Date:** 2/14/2014

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP REV:A NEW ISSUE 14-01-14 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4596-1 Spherical Bearing		Manufactured	No				Each	4.0000		6	FF	14-03-18	
				Location		**Loc Qty**		**Loc Code**					
				prelim		4				4			
					90581	4							
D4808-1P Rod End		Purchased	No				Each	0.0000		6	Lex SP 14-3-12		
M174PH-H900R1.000 17-4SS H900 ROUND BAR 1.00		Purchased	No				f	104.0000		2	CL 14/01/30		
				Location		**Loc Qty**		**Loc Code**					
				MAT031		104							
					m126952 ✓	44				2			
					m127334	60							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

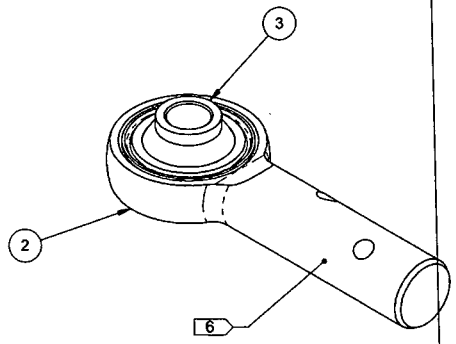
Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
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☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4808-041	ROD END BEARING ASSEMBLY
2	1	D4808-1	ROD END
3	1	D4596-1	SPHERICAL BEARING



#1 2028
14-1-28

D4808-041 ROD END BEARING ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.10 lbs
8) SWAGE D4596-1 BEARING INTO D4808-1 ROD END PER DART QSI 002 4.3
USING HIGH PERFORMANCE VEHICLE ENGINEERING SWAGING TOOL SWAG-4HM

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	RF	13.09.16

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	HS	DRAWING NO. D4808 — REV. A — SHEET 1 OF 2
MFG. APPR.	JLM	
APPROVED	HS	TITLE: ROD END BEARING — SCALE: NTS
DE APPR.	DS	
DATE	13.12.16	

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
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Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data	☐									
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Operator	☐									
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Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

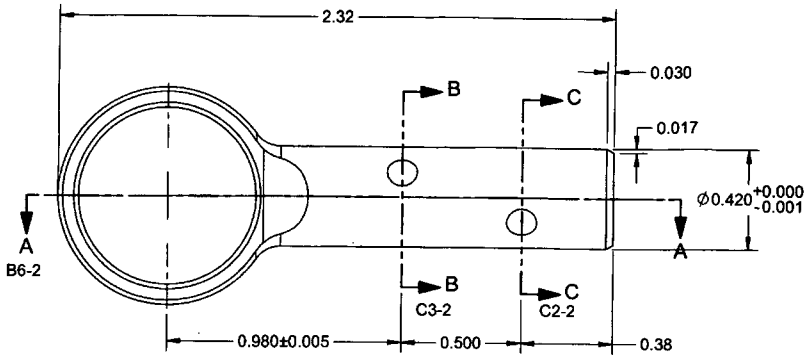
FAULT CATEGORY

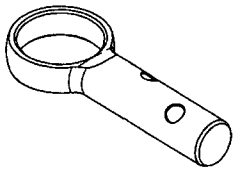
Landing Gear

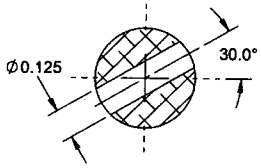
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☐ Centre Not Concentric
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☐ Cuffs
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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

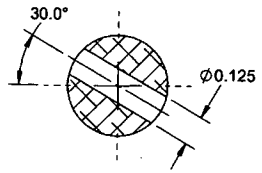
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other



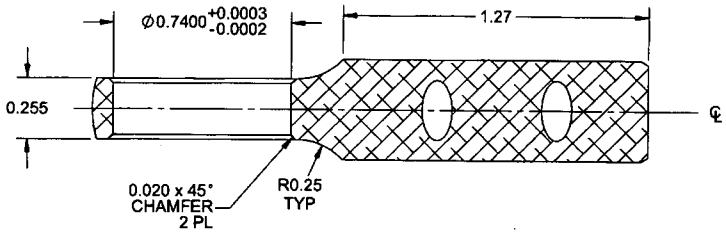




SECTION B-B C6-2

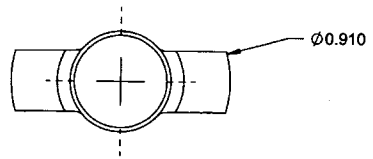


SECTION C-C C5-2



SECTION A-A C7-2

#112028.



RELEASED
LD 2016-12-09 LD

D4808-1 ROD END

NOTES:
1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.07 lbs
8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	HS	DRAWING NO. D4808 REV. A
MFG. APPR.	JLM	SHEET 2 OF 2
APPROVED	HS	TITLE ROD END BEARING SCALE NTS
DE APPR.	DS	
DATE	13.12.16	

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A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 907542 Date: 12-Mar-14

To

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Ship To

Michael Gregoire
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613 632-9577 Fax: 613 632-1053

Terms	Ship Via

Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
6 ea	Part: D4805-3P END FITTING Job: 15716	PO: PO22838	Rev: A Line: 13
4 ea	Part: D4805-5P END FITTING Job: 15717	PO: PO22838	Rev: A Line: 14
3 ea	Part: D4806-1P CLEVIS Job: 15709	PO: PO22838	Rev: A Line: 6
6 ea	Part: D4808-1P ROD END Job: 15710	PO: PO22838	Rev: A Line: 7
7 ea	Part: D4869-1P END FITTING, EYE Job: 15711	PO: PO22838	Rev: A Line: 8
3 ea	Part: D4869-3P END FITTING, EYE Job: 15712	PO: PO22838	Rev: A Line: 9

DATE : 12/03/2014

CERTIFIED SIGNATURE:

RECEIVER SIGNATURE : _____

SP 14-3-12.

CERTIFICATE OF CONFORMANCE

A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT ARE IN CONFORMANCE WITH THE REQUIREMENTS, SPECIFICATIONS, AND DRAWINGS REFERENCED IN THE ABOVE PURCHASE ORDER.

First Article Inspection Report

ATG INDUSTRIES INC.

731 Industrielle St
Rockland, Ontario K4K 1T2
Ph: 613 446-4544

Customer:	Dart Aerospace	Date:	March 12th, 2014	456
Part Number:	D4808-1P	Revision:	A	
PO Number:	PO22838	Qty:	6	FAI No.

Item	Dimension	Measurement Inspected by: Rene Tougas, Q.C.	Remarks
1	2.32	2.321	
2	.030	.032	
3	.17	.016	
4	Ø.420+.000/-.001	Ø.4200	
5	.38	.380	
6	.500	.500	
7	.980±.005	.9835	
8	30º	30º	
9	Ø.125	Ø.125	
10	Ø.125	Ø.125	
11	30º	30º	
12	Ø.7400+.0003/-.0002	Ø.7398	
13	1.27	1.277	
14	R.25 TYP	R.250	
15	.020 x 45º Chamfer	.020 x 45º Chamfer	2 Places
16	.255		
17	Material:	17-4SS H900 1.00" RD BAR	Supplied by Customer
18	Treatment:	Liquid Penetrant	PO#20140098

COPY

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22838

Purchase Order Date 1/30/2014
PO Print Date 1/30/2014

Order From : VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name		**Buyer**	Michael Gregoire
Vendor Phone	613-446-4544	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

Line Total: **$384.00**

6	D4806-1P	Clevis	3/7/2014 Yes 3/7/2014	3.00 Each		$235.00	$705.00

Manufacture as per drawing D4806 rev.A
Made from 17-4SS H900 Round Bar 1.000"
B112026

Line Total: **$705.00**

7	D4808-1P	Rod End	3/7/2014 Yes 3/7/2014	6.00 Each		$71.75	$430.50

Manufacture as per drawing D4808 rev.A
Made from 17-4SS H900 Round Bar 1.000"
B112028

Line Total: **$430.50**

8	D4869-1P	End Fitting, Eye	3/7/2014 Yes 3/7/2014	7.00 Each		$71.75	$502.25

Manufacture as per drawing D4869rev.A
Made from 17-4SS H900 Round Bar 1.000"
B112014

SP 14-3-12.

PO Instructions: Procurement Quality Clauses
A004 FAA-PMA /TSO
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A016 PERSONNEL QUALIFICATION
A024 PROCESS CERTIFICATIONS
A025 CERTIFICATE OF CONFORMANCE
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM

skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20177	**Customer:** Cash Sale	**Dept:** NDT YUL	**Reference:** 20140098
Descr:	**PN:**	**S/N:**	**Qty:** 1
Make:	**Model:**	**Reg:**	**A/C S/N:**
TSN: 0	**CSN:** 0	**TSO:** 0	

Task: UNSCHEDULED | **Sequence:** 1

Work Required:

CARRY OUT NDT ON 33 PARTS AS PER PO: 20140098

Action Taken:	Date:	Initial/Stamp:
LPI C/O ASTM E-1417M-13 NO CRACK FOUND PEN.(ZL-37 , B#10A070), CLEAN(SKC-S,B#09F21K),DEV.(SKD-S2,B#09L04K) EMU.(ZR-10B,B#10A074).	MAR 10 2014	DOT - APP 20 53-89

Description	*Location*	*P/N*	*Qty*	*Batch*	*S/N Off*	*S/N On*

COPY

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	**ACA/SCA Stamp**	Date:
Name: RAFIK MELIKIAN	DOT - APP 20 53-89	MAR 10 2014